

Tuesday, June 27, 2017 11:36:57 AM

163395

Page 1

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 7/6/2017 **Start Qty:** 4.00 ***4***

Cust Item ID:

Required Date: 7/13/2017 **Req'd Qty:** 4.00 *** 1 ***

Customer:

Reference:

Approvals:	Process Plan: <u>21</u>	Date: <u>JUL 03 2017</u>	Tooling: _____	Date: _____	Run	Start	*NR1*
	QC: <u>9-89</u>	Date: _____	SPC (Y/N): _____	Date: _____		Stop	*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D5122	A

100

2.57

100

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

2.33

HAAS CNC vertical machine #1

Machine as per Folio FB324

Folio Rev: 4A

Dwg Rev: A

Deburr

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.04

Quality Control

DAS

39

9-89

17-07-24

DAS

39

9-89

17-07-28

Work Order ID 163395

Tuesday, June 27, 2017 11:36:57 AM

163395

Page 2

Item ID: D5122-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Center Support, Upper
 Start Date: 7/6/2017 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 7/13/2017 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.08				4	0		DAS 45 9-89
Quality Control									2017-7-24
130	Identify as per dwg & Stock Location: <u>LG53</u>	0.00							
130									
Packaging	Memo	0.04				4			DAS 41 9-89
Packaging	LOCATION: <u>LG54</u>								JUL 25 2017
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.40							17/7/25
Quality Control									

DAS
21
9-89

JUL 25 2017

Picklist Print

Tuesday, June 27, 2017 11:36:55 AM

Page 1

Work Order ID: 163395

163395

Parent Item: D5122-1

D5122-1

Parent Item Name: Center Support, Upper

Start Date: 7/6/2017

Required Date: 7/13/2017

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV.A NEW ISSUE JFS 14/07/16 VERIFIED BY: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D5122-1TRN		Manufactured	No			100	Each	9.0000	0.5	2			DAS 39 9-89
D5122-1TRN									**		2	17-07-24	
Center Support, Upper, Turning Detail													

Location

Loc Qty

Loc Code

MAT060

9

155452

9

2

DART AEROSPACE LTD		Work Order: 163395
Description: Center Support		Part Number: D5122-1
Inspection Dwg: D5122	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	1.182	1.202		1.180	1.187	1.195	1.1905	
AB	0.090	0.110		.0985	.097	.0995	.0998	
AC	0.545	0.565		.553	.557	.552	.552	
AD	3.690	3.700		3.6945	3.6945	3.695	3.695	
AE	3.550	3.560		3.5545	3.5545	3.555	3.555	
AF	2.453	2.473		2.462	2.462	2.463	2.463	
AG	1.261	1.281		1.270	1.275	1.275	1.275	
AH	0.150	0.210		.180	.180	.180	.180	
AI	0.454	0.474		.462	.462	.463	.463	
AJ	Ø0.260	Ø0.267		.260	.260	.260	.260	
AK	Ø0.188	Ø0.194		.189	.189	.189	.189	
AL	3.067	3.077		3.072	3.072	3.072	3.072	
AM	3.990	4.010		3.996	3.997	3.997	3.997	
AN	1.990	2.010		2.005	1.996	2.003	1.998	
AO	Ø0.625	Ø0.630		.626	.626	.626	.626	
AP								
AQ								
AR								
AS								
AT								
AU								
AV								
AW								
AX								
AY								
AZ								

Ensure that Ø " bore is perpendicular to " bore within "

Accept/Reject .002 .0015 .0015 .0015

DAS

Measured by: 39

Date: 17-07-24

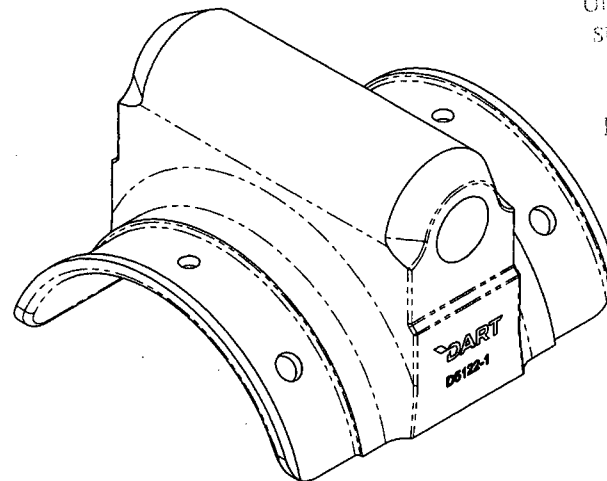
Audited by: 45

Date: 2017-7-24

Preliminary Approval: 9-89

Date:

Rev	Date	Change	Revised By	Approved
A	15.03.12	New Issue	KJ	



D5122-1 CENTER SUPPORT

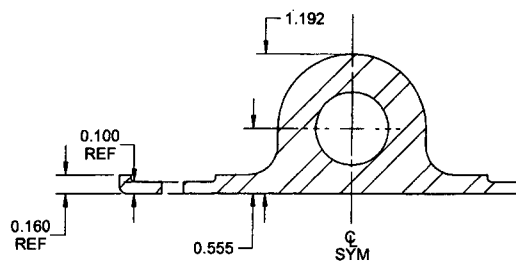
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 163395 *MLC*
170703

RELEASED
2014-08-25
MP

NOTES:

- 1) MATERIAL: MAKE FROM D5122-1TRN
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART LOGO AND P/N "D5122-1" IN AREA SHOWN
USING 0.125 HIGH X 0.010-0.020 DEEP LETTERING PER DART QSI 044 6.3,
IDENTIFY WITH DART B/N PER DART QSI 044 6.1
- 7) WEIGHT: 2.13 lbs
- 8) ALL NON-DIMENSIONED FEATURES DEFINED PER DRAWING FILE "D5122-1-REVA.SLDPRT"

APPROVED	A	NEW ISSUE		AP	14.06.02
	REV.	DESCRIPTION		BY	DATE
	DESIGN	AP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
	DRAWN	AP			
	CHECKED	CP	DRAWING NO. D5122		REV. A
	MFG. APPR.	JLM			SHEET 1 OF 3
	APPROVED	MP	TITLE		SCALE
	DE APPR.	DS	CENTER SUPPORT		NTS
DATE		14.06.02		COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE LOANED, REPRODUCED, COPIED OR OTHERWISE DISCLOSED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



SECTION A-A

HOLES PERPENDICULAR
WITHIN 0.005 OVER
ENTIRE LENGTH

R0.063
AROUND INSIDE EDGE

0.464 REF

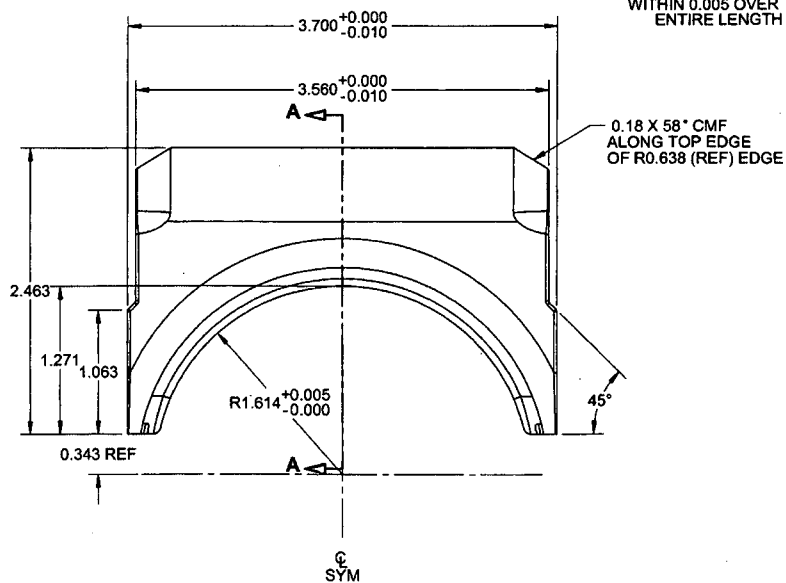
OPTIONAL $\phi 0.261$ REF
TOOLING HOLE,
LOCATED AT 45° TO VERTICAL
4 PL

OPTIONAL $\phi 0.189$ REF
TOOLING HOLE,
2 PL

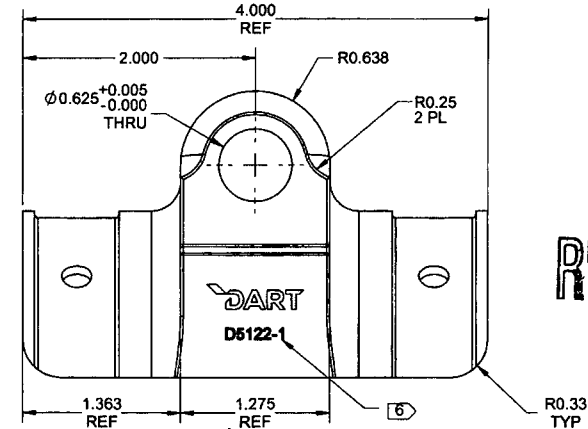
HOLES PERPENDICULAR
WITHIN 0.005 OVER
ENTIRE LENGTH

3.072 REF

4.000
REF



D5122-1 CENTER SUPPORT



RELEASED
2014-08-25

APPROVED

DESIGN	AP
DRAWN	AP
CHECKED	CP
MFG. APPR.	JLM
APPROVED	MP
DE APPR.	DS
DATE	14.06.02

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D5122	REV. A SHEET 2 OF 3
TITLE CENTER SUPPORT	SCALE NTS
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